

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010074**Date Inspected:** 21-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Du Zhi Qun, Li Ming, Chen Ying			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11 West Tower lift 3 corner triangle plate to skin

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSTL3-4B/K-1, 3
WSTL3-4C/K-1, 2
WSTL3-4F/K-72, 73
WSTL3-4D/K-65, 66

This Quality Assurance (QA) Inspector observed the following work in progress:

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STRUT PLATE

SMAW welding of weld joint 10B located on ED1-A6003-6.

Welder is identified as 040333. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 40 located on ED1-A6001-5.

Welder is identified as 070432. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

SOUTH TOWER INTERIOR SPLICE PLATE

FCAW welding of weld joint 1B located on SSD1-SPSA3-70.

Welder is identified as 053870. ZPMC QC is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SMAW welding of weld joint 1A/B(Repair) located on ED1-A5007-12.

Welder is identified as 053049. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G-REPAIR.

During random verification Visual Testing (VT) of shear plates on skin C and skin E of West tower lift 1, located in the Milling station, Caltrans Quality Assurance (QA) Inspector observed 'free hand thermal cutting' being carried out by ZPMC personnel. Access to the areas being cut, did not appear to be restricted due to cross sectional geometry and or position in so far as mechanical guides could not be used. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh
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Quality Assurance Inspector

Reviewed By:	Clifford,William
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QA Reviewer
